

### **Abstract**

An article machining apparatus is disclosed for use with a machine vise. The apparatus includes an article holding fixture with a securing section having a connecting bridge, foot and attached locator gauge pins. The fixture is oriented in the vise at a desired predetermined angle using three point contact of the fixture within the vise according to the dimensions stipulated in a MSN Excel program that provides variable data when fixed data such as the angle of machining the article is enclosed in addition to the diameters of the gauge pins and parameter dimensions of the fixture.